

Work Order ID 79519

79519

Page 1

January-26-12 4:08:09 PM

Item ID: D2746

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 26/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 12/01/27

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2746

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2746 Dwg Rev: C Prog Rev: C 2-

Debur if necessary

1010

.040

10

0

Jm

12-4-24

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10

0

Jm

12-4-24

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sedley/24

(10)

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

N/A

140

0.00

140

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on CNC Brake as per Dwg D2746 using Jigs DT8261 and DT83262-
Form joggle on Punch as per Dwg D2746 using Jig DT8158 Identify as D2746

(10)

SR
12/04/25

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

Sizley/25

(10)

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Item Name: Wearshoe

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 2:30								
	FINISH TIME: 3:00								
	OVEN TEMPERATURE:								
170	QC3- Inspect Part Finish	0.00							
170									
QC		0.00							
Quality Control	Memo								
180	Identify as per dwg & Stock Location: 496A	0.00							
180									
Packaging		0.00							
Packaging	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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January-26-12 4:08:09 PM

Item ID: D2746 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 26/01/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/4/30 JF
 U 12.04.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January-26-12 4:08:13 PM

Page 1

Work Order ID: 79519

79519

Parent Item: D2746

D2746

Parent Item Name: Wearshoe

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: D02.10.24Re-formatKJ
 IPP Rev: E 06-03-21 as Per Rev C JLM
 IPP Rev: F 06-06-12 Now On Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased		No		110	sf	121.7000	0.406	4.273684			

M1010S20GA

1010/1025 SHEET

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	121.7	
111410	45.2	
116791	76.5	

116791

12-4-24

W/O:		WORK ORDER CHANGES					
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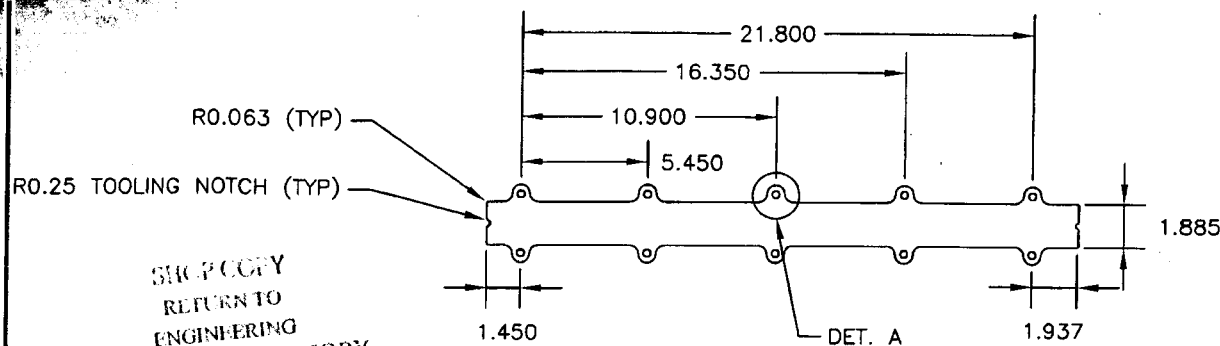
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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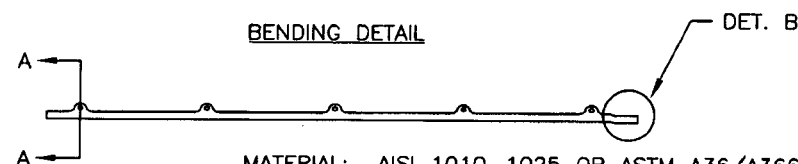
NOTE: Date & initial all entries

DART**RELEASED**
02074

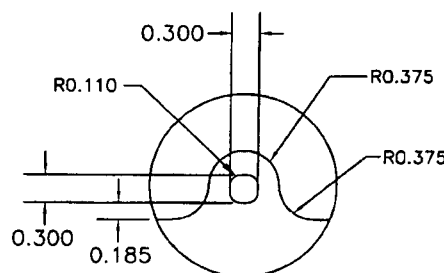
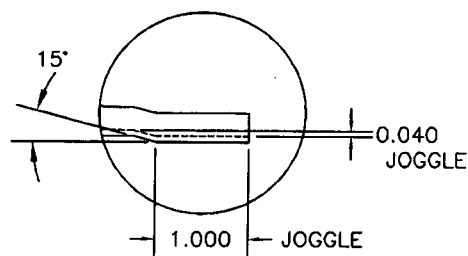
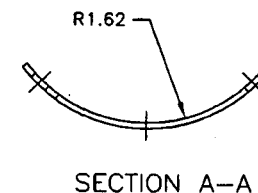
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
F1	F1	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2746
DATE	TITLE	SHEET 1 OF 1
06.01.12	WEARSHOE	SCALE
A	98.04.16	NEW ISSUE
B	98.08.18	RE-DESIGN
C	06.01.12	ENLARGE HOLES TO IMPROVE FIT

FLAT PATTERN

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 79519 M.C.5
12/01/27

BENDING DETAIL

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)

**DETAIL A****DETAIL B****SECTION A-A****NOTES**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL, 20 GAUGE (0.040 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) THIS PART CAN BE MADE BY MODIFYING D2656-21

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